

split 08/05/24
SD 08/05/24Data: Friday, 23/05/2008 8:26:49 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MIRROR ARM	
Job Number	: 39431-2		Part Number	: D2010104	
Estimate Number	: 10335		Drawing Number	: D2010 REV. C2	
P.O. Number	:		Project Number	: N/A	
This Issue	: 23/05/2008 S.O. No. :		Drawing Revision	:	
Prsht Rev.	: NC		Material	:	
First Issue	: 11 Type : SMALL /MED FAB		Due Date	: 30/05/2008 Qty: 20	
Previous Run	: 39208		Um:	Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est A 04.02.17 New issue KJ/JLM				

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W049	304 RD Tube .500 x .049W	
		Comment: Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall (M304TR0500W035) 049	Batch No: M107518 SEE ATTACHED 23 08/05/23 (20)
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104	23 08/05/23 (20)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr	23 08/05/23 (20)
4.0	D2057	Plug	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Plug batch: B39432	FF 08-05-27 (20)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010	FF 08-05-27 (20)

W/O: 39431-2

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-05-23	1	USE M304TR0500W049 Tubing instead $\varnothing 0.500 \times 0.035$ wall PERMANENT CHANGE	RL	08-05-23	HLC	RL 08J 042 SEE ATTACHED	

Part No: DZ010-104 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 8:25:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39431

Part Number: D2010104

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/27 (19)

7.0 POWDER COATING

POWDER COATING



M105642



(19)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 1:50

1:50

OVEN TEMPERATURE: 320

320

FINISH TIME: 2:20

2:20

M.F.

08/05/27

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



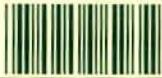
(19)

Comment: INSPECT POWDER COAT

Fd 08/05/27

9.0 PACKAGING 1

PACKAGING RESOURCE #1



8/5/27 SP

Comment: PACKAGING RESOURCE #1

POSITIVE RECALL

Identify and Stock

EFFECTIVE 08/05/23

Location 208

AUTH 7

REF FASER

DATE

08/05/27

(19)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M.F. 08-05-28

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: May 12, 2008 2:28 PM
To: 'Chris Provencal'; 'Mike Petsche'
Cc: 'Peter Hum'; 'Bill Beckett'
Subject: RE: R44 Mirror arm D2010-104

This deviation is acceptable.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Monday, May 12, 2008 11:55 AM
To: 'Mike Petsche'; David Shepherd (David Shepherd)
Cc: Peter Hum; Bill Beckett
Subject: RE: R44 Mirror arm D2010-104

David,

If we make a tube with 0.049" wall, can we sign this off as a deviation on the w/o? That's the quickest way to get it out the door.

If this will be a permanent change we'll eventually need a new dwg and a new CHG #.

-Chris

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: May 12, 2008 9:36 AM
To: 'Bill Beckett'; 'Dan Stow'; 'Chris Provencal'
Cc: 'L Lacelle'; 'David Shepherd'; 'Peter Hum'
Subject: RE: R44 Mirror arm D2010-104

I assume someone's raising a new NCR.....We had one open from the last time this happened but we never ended up getting broken part back. Pretty sure we ended up shutting it down.

It should be directed to Peter.

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: May 12, 2008 9:27 AM
To: 'Dan Stow'; 'Mike Petsche'; 'Chris Provencal'
Cc: 'L Lacelle'; 'David Shepherd'
Subject: RE: R44 Mirror arm D2010-104

Dan - Yup, let's send him a replacement mirror arm, but I don't want to send out something that has a good chance of failing.

Chris - I suggest we make an arm with 0.049" wall vs. the 0.035" called up on the drawing, and that we sign this off as a deviation. If this is acceptable, please advise Linda ASAP.

Mike - we need to come up with a permanent solution to this issue ASAP - I believe this will apply to the R22 and MD500 as well.

Bill

From: Dan Stow [mailto:dstow@dartaero.com]
Sent: May 12, 2008 8:05 AM
To: Bill Beckett (Bill Beckett)
Subject: FW: R44 Mirror arm D2010-104
Importance: High

Bill,

I sent you this email last week. I am sending Russ to CHC today to pick up the skid and I need to know if you would like to send Claude a new R44 mirror arm and pick up the one that is cracked.

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: CBoule@canadianhelicopters.com [mailto:CBoule@canadianhelicopters.com]
Sent: May 8, 2008 10:04 AM
To: Dan Stow
Subject: RE: R44 Mirror arm D2010-104

Hi Dan

We have few that cracked.

I have in my hand one the cracked strut, can I shipped it to your attention , have your Engineer group to look at it for a fix.

Claude Boulé
Chief Engineer, VFR, Qc/ On/ Nb.
Tel: 450-452-3025
Fax: 450-452-2483
cboule@canadianhelicopters.com

"Dan Stow" <dstow@dartaero.com>

20/12/2007 04:15 PM

To <CBoule@canadianhelicopters.com>

cc

Subject RE: R44 Mirror arm D2010-104

Hi Claude,

16/05/2008

I have heard about this problem once before and I thought that it might be an isolated incident... I guess not. I will bring this to the attention of the design team. If you could please supply me with the Batch # of the mirror assembly and a shipping address I will send out a new arm ASAP.

Thanks for the feedback.

Dan Stow
Technical Support
Dart Aerospace
Tel: 613.632.5200
Cell: 613.676.0992
dstow@dartaero.com

From: CBoule@canadianhelicopters.com [mailto:CBoule@canadianhelicopters.com]
Sent: December 20, 2007 3:53 PM
To: dstow@dartaero.com
Subject: R44 Mirror arm D2010-104

Hi

We have been replacing the D2010-104 due to crack at the mirror attachment.

It is a weak point of the design.

See attached pictures.

Were you aware about This defect?

Claude Boulé
Tel: 450-452-3025
Fax: 450-452-2483
cboule@canadianhelicopters.com

No virus found in this incoming message.
Checked by AVG.
Version: 7.5.524 / Virus Database: 269.23.16/1427 - Release Date: 11/05/2008 1:08 PM

No virus found in this outgoing message.
Checked by AVG.
Version: 7.5.524 / Virus Database: 269.23.16/1427 - Release Date: 11/05/2008 1:08 PM

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1428 - Release Date: 5/12/2008 7:44 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1428 - Release Date: 5/12/2008 7:44 AM

